

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029565**Date Inspected:** 07-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** USA Hoist, Crest Hill, IL**CWI Name:** None present**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Elevator guide rails**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the Fabricator's shop and observed the work and the inspection performed by USA Hoist personnel. The inspection was performed on the Tower elevator guiderail poles. The welding was performed utilizing Flux-Cored Arc Welding with shielding gas process (FCAW-G) as per the approved Welding Procedure Specifications (WPS's).

At the start of the shift this QAI observed the following:

No Quality Control (QC) inspector was present this day.

This QAI witnessed the the fit-ups and welding in progress of the Tower Elevator guiderail poles. The welding was being performed by Jose Dominguez #C as per the prequalified WPS FCAW-3210, and WPS FCAW-3139 using the gas-shielded Flux Cored Arc Welding (FCAW-G) process. The electrode that was being utilized was E71T-1 Kobe Familiarc .045 diameter flux-cored wire as per AWS A5.20 and as allowed per the AWS D1.1 Structural Welding Code. The shielding gas utilized was a 75% Argon/25% CO2 mix and was delivered at a flow rate of 35 Cubic Feet per Hour (CFH) as per both WPS FCAW-3210 and WPS FCAW-3139.

This QAI mentioned again to USA Hoist's Engineer Robert Overbeek that some of welds of the Tower Elevator guiderail poles were undersized to a small degree per the provided welding symbols on the shop design drawings. In particular, the welds of the pipetube connection items #10 to the bent plate brackets lacked some throat dimension. This QAI offered to go over the welds with the Engineer toward a resolution, at a time convenient to him and expedient to the project's needs.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Morris, Monty	Quality Assurance Inspector
Reviewed By:	Foerder, Mike	QA Reviewer
